

Slip 16/07

Dart Aerospace Ltd.

29

Date: Wednesday, 7/11/2007 2:32:47 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARMOR SHIELD
Job Number	: 33499		
Estimate Number	: 12375		
P.O. Number	: N/A	Part Number	: D206667101A
This Issue	: 7/11/2007 S.O. No. : N/A	Drawing Number	: DSI9326
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 32013	Material	: N/A
Written By	:	Due Date	: 7/16/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.07.11</u>		
Comment	: Est Rev: A New Issue 06-04-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD206-667-101A CHG001  
Add DSI 9326 to existing paper work.

07.07.12 JA

2.0	D206667101	Crosstube Installation
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Fwd Crosstube  
Batch: 29099 RT 07-07-12

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
1-Remove tube from packaging

2-Apply Armor sheild as per DSI 9326  
A/R Armor Sheild Batch: 104994 RT 07-07-14

4.0	QC14	INSPECT SPRAY PAINT
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Comment: Inspect Spray Paint

07.07.16

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5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D206-667-101A  
Location: \_\_\_\_\_  
PPP Rev: \_\_\_\_\_

Rev Draft 7/16/07 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:32:47 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMOR SHIELD

Job Number: 33499

Part Number: D206667101A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



02.07.17 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 07-07-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J.J.</i>	APPROVED <i>J</i>	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14		TITLE ARMOR SHIELD	SCALE NTS
A	06.02.14	NEW ISSUE	

## DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101/-201	SH01-9	SR01298NY
D412-664-203		
D206-667-101/-103/-201/-203	SH01-5	SR01304NY
D407-667-105/-205		
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

### 1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area.
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

### 2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch-up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

SHOP COPY

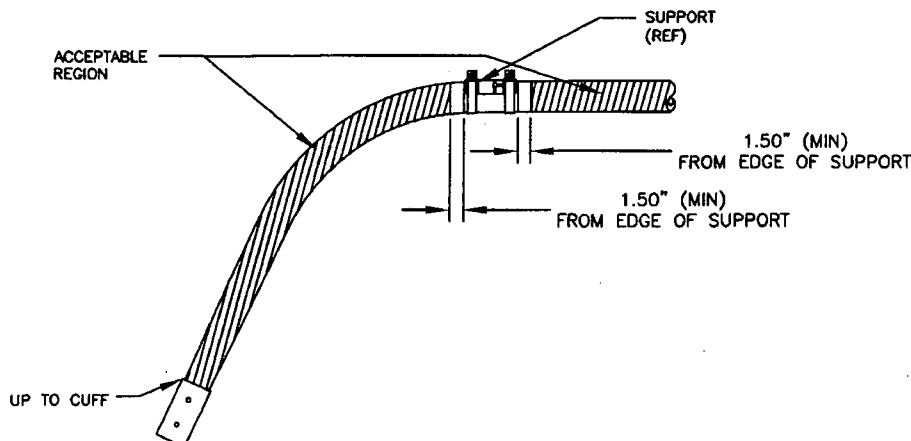
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 33500

**FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 06.02.14  
CERT. NO.: SH03-6/SH01-9/SH01-5  
ISSUE NO.: 3/3/3

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